

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010930**Date Inspected:** 31-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 5 East)

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 5 East for smoothness. Below locations not complies with the ABF inspection report no: CWAHIR-5E-03 dated 30th Dec 2009. Those locations flush grinding and sharp edges removal required. All these details noted and forwarded to team leader for further action.

Location E4 - Panel point 31(Facing East) - Floor beam to bottom panel cope hole

Location E4 - Panel point 31(Facing East) - Floor beam to side panel cope hole

Location E3 - Panel point 32(Facing East) - Floor beam to bottom panel cope hole

Location E3 - Panel point 32(Facing East) - Floor beam to side panel cope hole

Location E4 - Panel point 32(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E4 - Panel point 33(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E3 - Panel point 35(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E4 - Panel point 35(Facing East) - Floor beam to bottom panel cope hole

Location E4 - Panel point 35(Facing East) - Floor beam to side panel cope hole

Location E4 - Panel point 35(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E3 - Panel point 36(Facing East) - Floor beam to bottom panel cope hole

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Location E3 - Panel point 36(Facing East) - Floor beam to side panel cope hole

Location E4 - Panel point 36(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

FCAW Process:

Welding of weld joint – 301 and 302 located on PCMK SEG027F, fillet weld joining longitudinal diaphragm web and bottom panel. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

FCAW Process:

Welding of weld joint – 303 located on PCMK SEG027F, Complete Joint Penetration weld joining longitudinal diaphragm web and bottom panel. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

OBG # TRIAL ASSEMBLY YARD (6AW)

SMAW Process:

Welding of misdrilled holes on T-Rib located on 6AW facing 5CW segment. Welder is identified as 220066. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR9619 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair-Misdrilled hole.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer